



Dart Aerospace Ltd.
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D3017-7

Job Sheet 182042



12
33 11 → SCRAP

Part No: D3017-7

Job Qty: 30 ea

Part Name: Lug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/16/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP: B 03.05.09 Reformat KJ/RF IPP Rev:C 08-04-11 now made on water jet DD verified by:EC
IPP RevB: as per revB DD verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea	8/31/18	8/31/18	0.00	0.00	Start Up Waterjet		18/08/18
100	Waterjet	30 pcs	8/31/18	8/31/18	0.00	1.58	Waterjet1		18/08/18 DAS
120	QC	30 pcs	8/31/18	8/31/18	0.00	0.00	QC8		AUG 17 2018 38
130	Brake NC	30 pcs	8/31/18	8/31/18	0.01	2.48	Brake NC 1		smf DAS 89
140	QC	30 pcs	8/31/18	8/31/18	0.00	0.00	QC5		AUG 30 2018 68
150	Packaging	30 pcs	8/31/18	8/31/18	0.00	0.00	Packaging3 WA002		9-89
160	QC21-SA	30 Ea	8/31/18	8/31/18	0.00	0.00	QC21		18.09.04

Part Op 100 - 1-Cut as per Dwg D3017 2-Deburr

Descriptions: 130 - 1-Deburr 2-Form as per Dwg D3017 using DT9835

150 - Identify and bag with light oil (Vactra oil #2), then Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4130NS.049	4130 Sheet .049	3.0600 sf (.102 ea)	90-Start up Operation	80 F124283

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M4130NS.049	3	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lug	0.250Inches ± 0.030	0.280 0.220	Radius	
2	Lug	2.063Inches ± 0.010	2.073 2.053		
3	Lug	2.500Inches ± 0.010	2.510 2.490		
4	Lug	0.191Inches + 0.005 - 0.000	0.196 0.191	Diameter	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____	DISPOSITION Rework ☐ Scrap ☐ As-is ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>			Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Description Work Order: _____		MRB (QSI042) Approval _____																		
Completed By _____		Lead hand / Supervisor Approval Verification _____																		
QC / QA Coordinator Approval _____		_____																		

Root Cause			
Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Bend/b	☐	Cracks	☐	Inspection Incomplete	☐	Stock Pulled	☐	Positioned Wrong	☐
Centre Not Concentric	☐	Crimp/Kink/Ripple/Wave	☐	Contamination	☐	Off-set	☐	Outside Dimensions	☐
Cuffs	☐	Crushing	☐	Countersink	☐	Mislabeled	☐	Over/Under tolerance	☐
Heat Treat	☐	Wave/Twist in Tube	☐	Cut Too Short	☐	Fit/Function	☐	Part Incorrect	☐
Marks/Chatter	☐	Drill Holes	☐	Instructions Incomplete/Unclear	☐	Misaligned/off center	☐	Part Lost/Missing	☐
OTHER : _____									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>182042</u> Part No. <u>D3017-7</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☒</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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